

Y.I. TYPE

(15)

PROFILED DECKS

LITHGOWS LTD

No 957-8-9

-60-61.



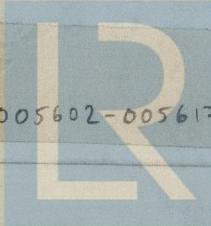
n/n " ACHEO"

Yard No.	Name	First Entry Rpt. No.
957	"EMPIRE RIDLEY"	21638
958	"EMPIRE BAFFIN"	21587
959	"EMPIRE HOWARD"	21645
960	"EMPIRE RANGER"	21746
961	"EMPIRE ZEAL"	21769

DS 287

© 2020

005602-005617-0238



Lloyd's Register
Foundation

No 957-8-9

SECRET & CONFIDENTIAL
EMERGENCY PROGRAMME

STEAM CARGO VESSEL - Y1 TYPE.

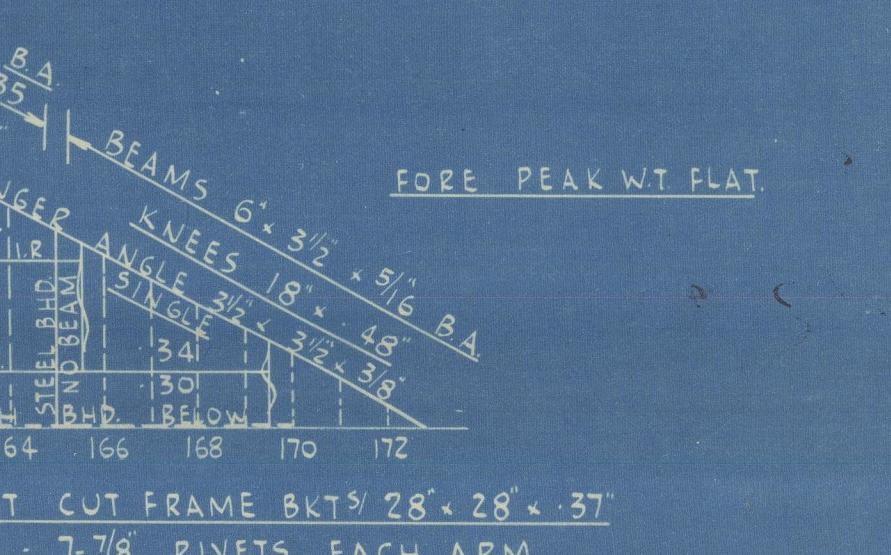
PROFILE & DECKS PLAN.

SCALE $\frac{1}{8}$ = 1 FOOT
DIMENSIONS - 426' 0" BP 36' LWL x 56' 0" MLW TO UPPER DECK
TO CLASS 100AI WITH FREEBOARD AT LLOYD'S SPECIAL SURVEY.
COMPLEX SUPERSTRUCTURE VESSEL.

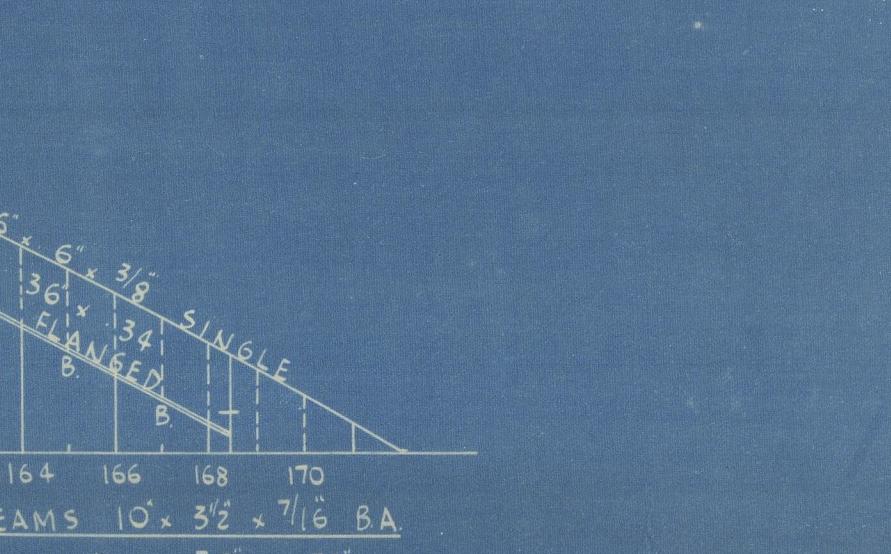
THE SCANTLINGS ARE SUITABLE FOR A DRAUGHT 18' IN
EXCESS OF THAT CORRESPONDING TO THE FREEBOARD
WHICH COULD BE ASSIGNED TO THE VESSEL. *for complete*
hydrostatics table showing a trumpet opening

THE SCANTLINGS OF ANGLE, BULB, ANGLE & CHANNEL
SECTIONS GIVEN ON THIS PLAN ARE NBS AND ARE IN
ACCORDANCE WITH THE EMERGENCY PROGRAMME LIST.

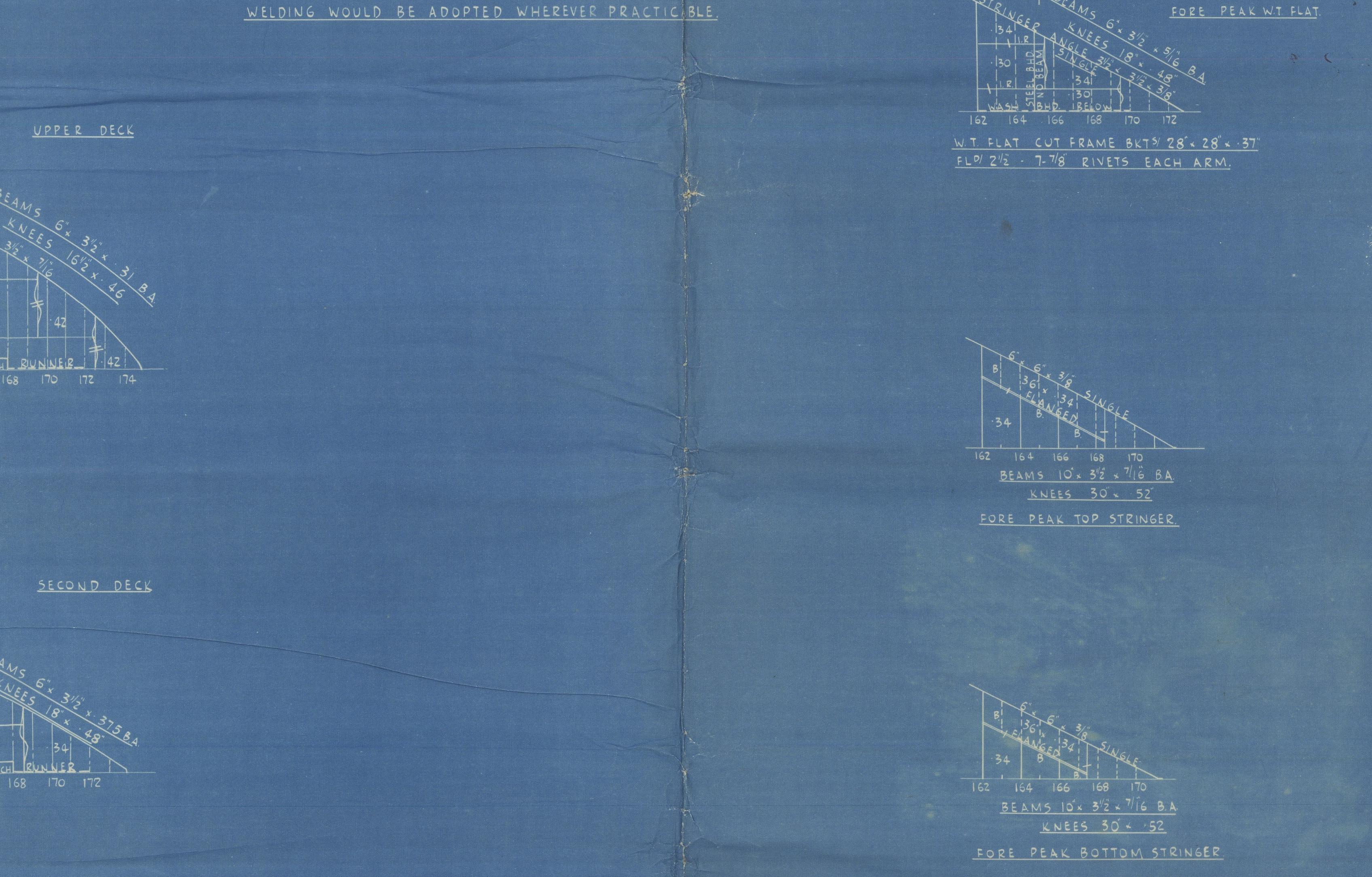
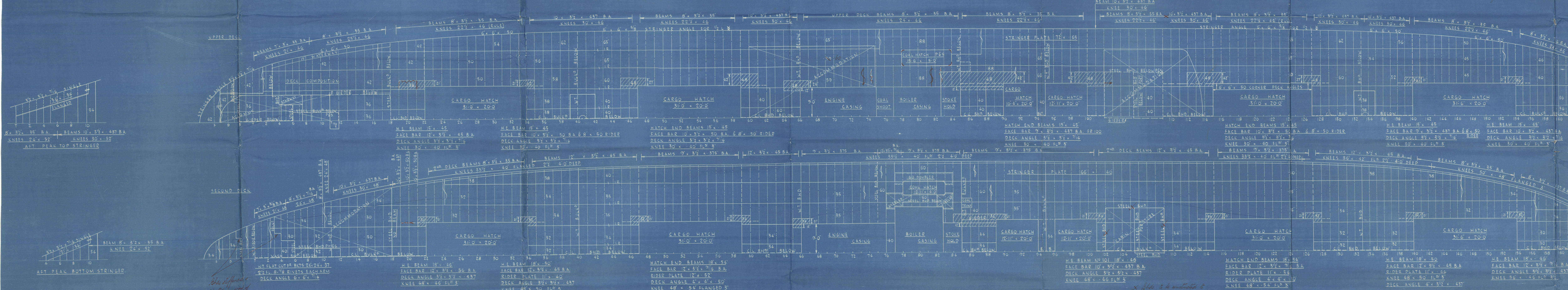
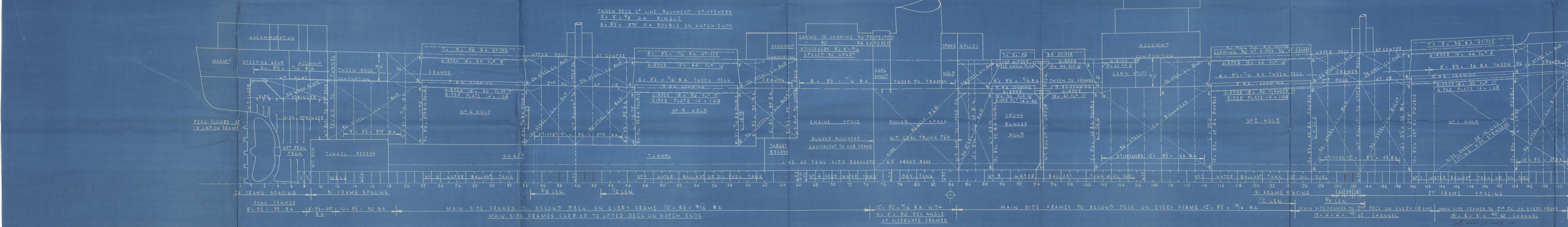
IN THE EVENT OF SCARCITY OF LABOUR, ELECTRIC
WELDING WOULD BE ADOPTED WHEREVER PRACTICABLE.



WT FLAT CUT FRAME ALTY 28° 28° 37°
FLP 21° 7° 7° RIVETS EACH ARM



FORE PEAK TOP STRINGER



LITHGOWS LTD

No 957

Y TYPE

EMPIRE RIDLEY

MIDSHIP SECTION

AS BUILT

n/n " Asched "

Greenock Report No 21638



© 2020

Lloyd's Register
Foundation

005602-005617-0239

LITTHGOWS LTD

Y TYPE

FITTED ON NOS 957-9 Only.

BUILT
WELDED
STERN FRAME

LLOYD'S APP.

14·5·40

No 957 n/n "Acheo"
EMPIRE RIDLEY ex 3

Greenock Report No. 21638

No 959

EMPIRE HOWARD

Greenock Report No. 21645

© 2020



005602-005617-0241

Lloyd's Register
Foundation

1007
100



© 2020

Lloyd's Register
Foundation

Also 969-70-1-2-7-8-9-80-1-2-90

Y1 + Y2 TYPE

(8)

LITHGOWS LTD NOS.

957/8/9/60/1/2/3/4/5

D.S. 28th

~~RUDDER~~

n/n "ACHEO"

Yard No.	Name	First Entry Rpt. No.
957	"EMPIRE RIDLEY"	21638
958	"EMPIRE BAFFIN"	21587
959	"EMPIRE HOWARD"	21645
960	"EMPIRE RANGER"	21746
961	"EMPIRE ZEAL"	21769
962	"EMPIRE SPARTAN"	21797
963	"EMPIRE CONRAD"	21846
964	"EMPIRE PRAIRIE"	21702
965	"EMPIRE ADDISON"	21770

Yard No.	Name	First Entry Rpt. No.
969	"EMPIRE AUSTEN"	21837
970	"EMPIRE CALAHAD"	21915
971	"EMPIRE LANCER"	22086
972	"EMPIRE PENNANT"	22115
973	"COOLCORM"	22116
976	"CAPE HOWE"	22190
977	"EMPIRE TREASURE"	22243
978	"EMPIRE BEATRICE"	22284
979	"EMPIRE BUCKLER"	21969
980	"EMPIRE PIBROCH"	22047
981	"EMPIRE FALSTAFF"	22342
982	"EMPIRE SERVICE"	22374
990	"EMPIRE FLORIZEL"	22357



© 2020

Lloyd's Register
Foundation

005602-005617-0240

STREAMLINE RUDDER.

S.S. N°s 957-8-9-60-1-2-3-4 & 5.

SCALE 1" = 1 foot
DETAILS AS INDICATED

DIMENSIONS:- 485'-0" B.P. x 56'-0" M.L.D. x 27'-9" M.L.D TO SECOND DECK:- 36'-9" M.L.D TO UPPER DECK.
TO CLASS 100 A.I. WITH FREEBOARD AT LLOYDS SPECIAL SURVEY.
LOAD DRAFT 26'-4" ACTUAL SHIP SPEED 10½ KNOTS - (LLOYDS MIN. SPEED FOR RUDDER - 12 KNOTS)
TOTAL IMMERSSED AREA OF RUDDER FROM FORE SIDE OF POST 131 SQ. FT.
CENTRE OF GRAVITY OF AREA FROM CENTRE LINE OF PINTLES - 4'349 FEET.
 $A \times D = 570$ DIAMB OF RUDDER STOCK - 12" DIR.
KEYWAYS ETC. TO BE CUT IN RUDDER STOCK TO PARTICULARS GIVEN.
RUDDER STOCK TO BE ACCURATELY TURNED TO DIMENSIONS GIVEN.
RUDDER FRAME TO BE ACCURATELY CAST TO SHAPE AS PER DETAILS.
RIVET HOLES TO BE BORED PLUMB THRO' FRAME, SIZE MUST NOT BE LESS THAN GIVEN.
RUDDER NOT TO EXCEED GIVEN SCANTLINGS EXCESS OVER EST. WEIGHT WILL NOT BE PAID
PATTERN OF RUDDER FRAME TO BE APPROVED BY SHIPBUILDERS' DESIGNER BEFORE CASTING.

NOTE:- ALL PINTLES TO BE SUPPLIED COMPLETE
BY RUDDERS MAKERS. PINTLES TO BE OF STEEL
MADE & EFFICIENTLY FITTED AS PER DETAILS.
BRASS BUSHES MUST BE TURNED IN ONE PIECE
AND PROPERLY SHRUNK ON PINTLES.

STRUCTION NOTE - RUDDER FRAME TO BE LAID ON TOP
OTTOM PLATE. ALL INSIDE SURFACES OF RUDDER TO BE
D WITH BITUMINOUS SOLUTION. CORK MIXTURE TO BE
D IN THE FOUR COMPARTMENTS TO TOP PLATE LEVEL.
LATE LAID IN POSITION ENTIRE RUDDER RIVETTED COMPLETE
MS CAULKED. BITUMINOUS SOLUTION POURED INTO EACH
ARTMENT UNTIL FULL. CLOSING DISCS WELDED INTO
NG HOLES & FILLET WELD ROUND LIFTING EYE. WRAPPER
S FITTED IN POSITION & WELDED AS INDICATED